

Date: Monday, 8/20/2007 9:21:12 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34112
 Estimate Number : 12342
 P.O. Number : N/A
 This Issue : 8/20/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 8/20/2007 Type : MACHINED PARTS
 Previous Run : 32806
 Written By : EC
 Checked & Approved By :
 Comment : Est Rev:A Removed from 9 Digit 06-03-22 JLM
 *****Custom pedal locks for Cobra*****

Drawing Name : PEDAL LOCK
 Part Number : D3368041
 Drawing Number : D3368 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 8/24/2007

Qty: 1 Um: Each

*CUSTOM
MODIFIED
FOR
COBRA*

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33681	Pedal Lock Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3368-1	BASE	A23534

07/08/20 ①

2.0	D33683	Pedal Lock Cover
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3368-3	COVER	A23535

07/08/20 ①

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Fill pedal slots with weld

Aluminum rod A/R batch: *M14666*

07/08/20 ①

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Mill slots to fit supplied Cobra pedals

07-08-21
Per. Attachment Sketch

07-08-21 ①

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK

Job Number: 34112

Part Number: D3368041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-08-21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-08-21

7.0

POWDER COATING

POWDER COATING



M18052



(1X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M-1

07/08/25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/08/27

9.0

D27287

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2728-7

Decal

022554

CP

10.0

D33737

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3373-7

Cam Lock

022167

B22944

CP

11.0

D33853

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3385-3

Hinge

022387

CP

07/08/2001

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Part Number: D3368041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 238-028 Ø3/16" Dowel Pin 1/2" long M16988 -

13.0

385039

8-32 Flat screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 385-039 Flat Head Screw M17356 -

14.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock B26372 -

15.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve M103927 -

16.0

CBL1240

Cable



Comment: Qty.: 2.3333 f(s)/Unit Total : 2.3333 f(s)

Pick:

Qty Part Number Description Batch

28" CBL-1240 Cable M102439 -

07/08/210

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Drawing Name: PEDAL LOCK

Job Number: 34112

Part Number: D3368041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN960416

Washer



CP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer 175519

18.0

HX81

1/4"-20 SHCS 3/8" long



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M16971

EF 07/08/210

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel.
Discard the rest.

Keys alike C420A ml 07/08/27

2-Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).

Pick:

Qty Part Number Description Batch

A/RN/A 262 Locktite M102855

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368

6-Ensure that keys are attached to D3368-041

ml 07/08/27

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EF 07/08/27

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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *See Draft*

7/8/27 SE

22.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Done 8/27

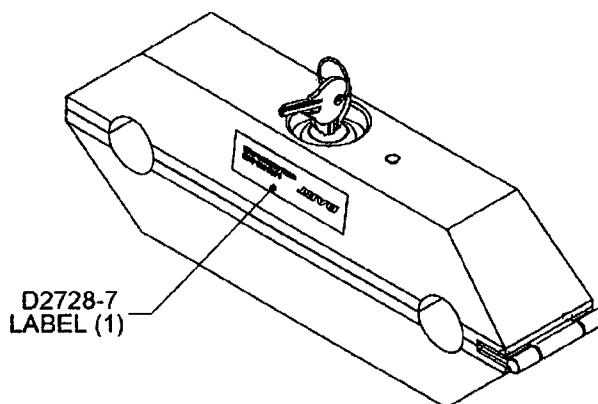
Job Completion



Done 8/27

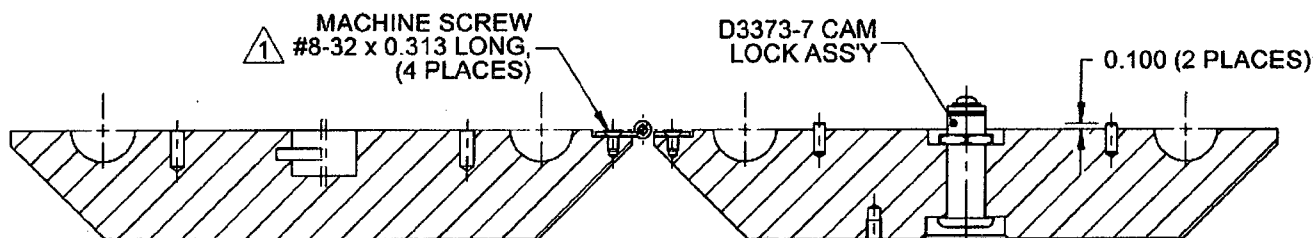


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

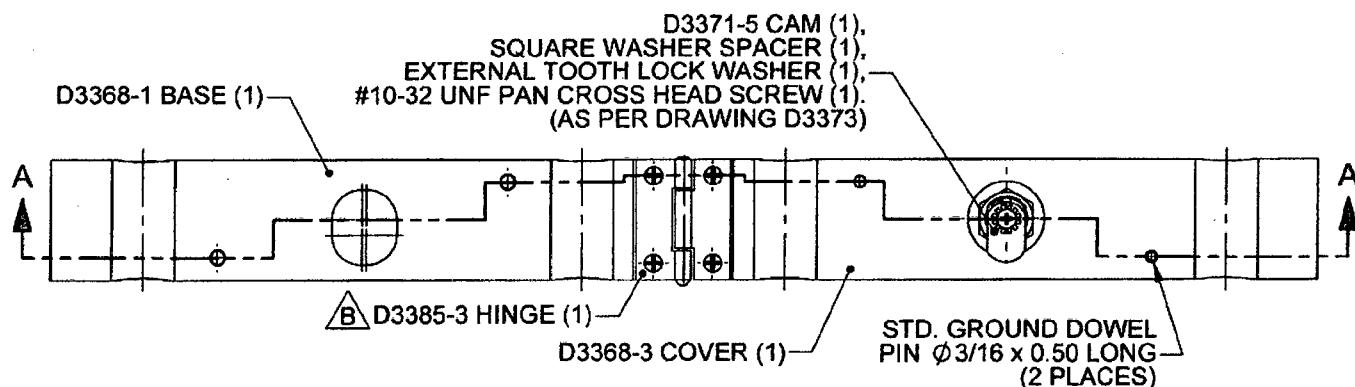


RELEASED
[Signature]
25/04/20

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

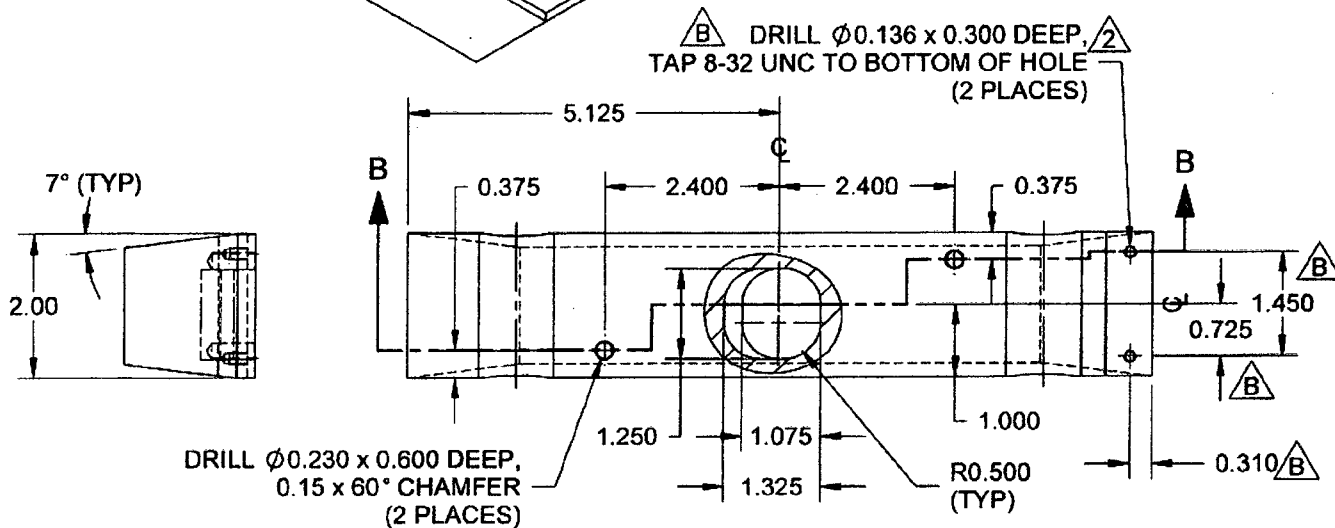
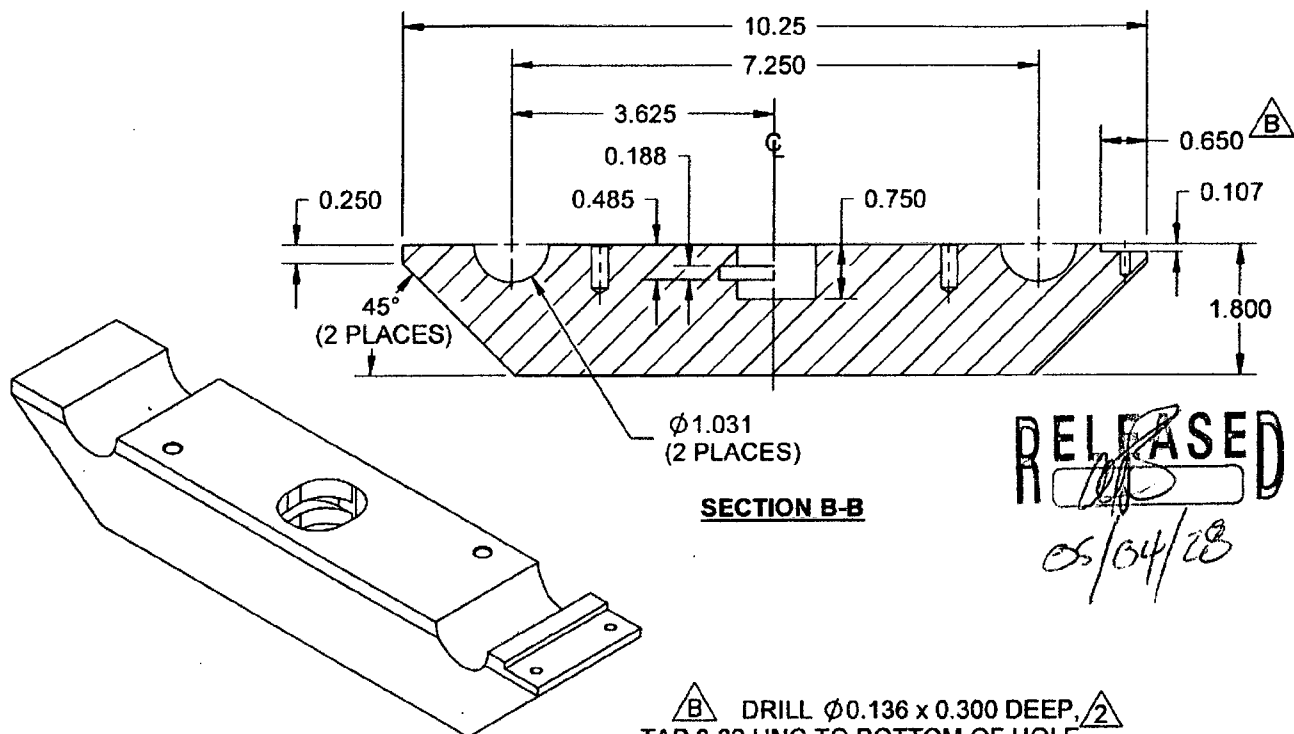
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

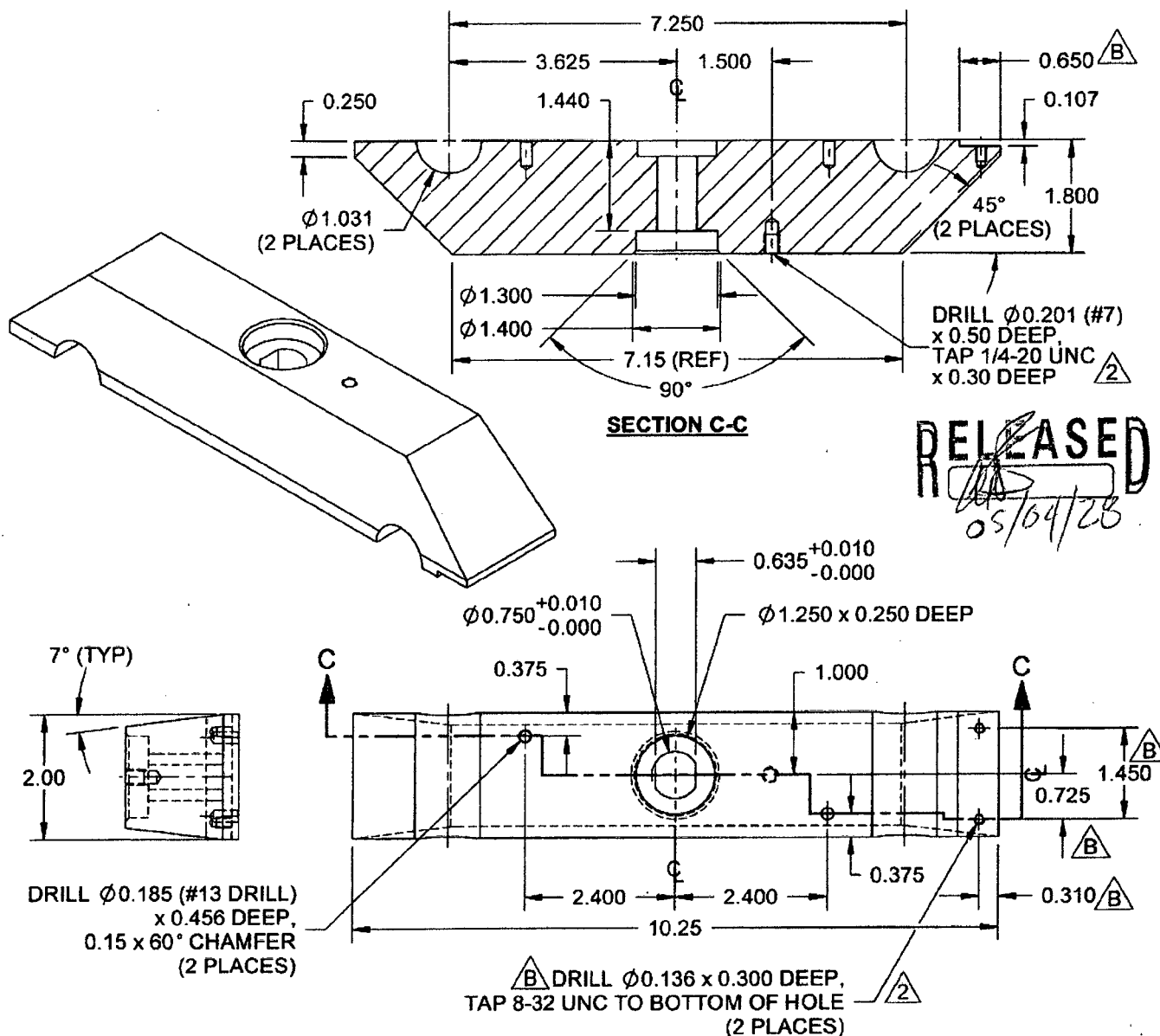
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



RELEASED
05/04/23

D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3669

COMMAN

~~OFFICE~~ PENAL LOCK

~~DOSS~~ ~~775~~

NO 34112

0.60"

20

5.050"

0

0

650

X.70-X

D3368-041

NO
THE
SA